

Customer	:	CU-DAR001 Dart Helicopters Services	Drawing Name	:	WEARPAD
Job Number	:	31037			
Estimate Number	:	10700			
P.O. Number	:	N/A	Part Number	:	D34291
This Issue	:	3/7/2007 S.O. No. : N/A	Drawing Number	:	D3429 REV A
Prsht Rev.	:	NC	Project Number	:	N/A
First Issue	:	N/A Type : PURCHASED PARTS	Drawing Revision	:	A
Previous Run	:	30237	Material	:	N/A
Written By	:	<u>[Signature]</u>	Due Date	:	3/15/2007 Qty: 30 Um: Each
Checked & Approved By	:	<u>[Signature] 07.03.07</u>			
Comment	:	Est: A 05.10.04 New Issue KJ/EC			

[illegible]

1.0 M1010S16GA 1010/1025/A21/6aA SHEET

[illegible]

10/10/01

1010/1025/A21/6aA steel sheet 0.063" thick

Batch: M103434 M1010313

30

2.0	WATER JET	FLOW WATER JET
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[illegible]

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100	101	102	103	104	105	106	107	108	109	110	111	112	113	114	115	116	117	118	119	120	121	122	123	124	125	126	127	128	129	130	131	132	133	134	135	136	137	138	139	140	141	142	143	144	145	146	147	148	149	150	151	152	153	154	155	156	157	158	159	160	161	162	163	164	165	166	167	168	169	170	171	172	173	174	175	176	177	178	179	180	181	182	183	184	185	186	187	188	189	190	191	192	193	194	195	196	197	198	199	200	201	202	203	204	205	206	207	208	209	210	211	212	213	214	215	216	217	218	219	220	221	222	223	224	225	226	227	228	229	230	231	232	233	234	235	236	237	238	239	240	241	242	243	244	245	246	247	248	249	250	251	252	253	254	255	256	257	258	259	260	261	262	263	264	265	266	267	268	269	270	271	272	273	274	275	276	277	278	279	280	281	282	283	284	285	286	287	288	289	290	291	292	293	294	295	296	297	298	299	300	301	302	303	304	305	306	307	308	309	310	311	312	313	314	315	316	317	318	319	320	321	322	323	324	325	326	327	328	329	330	331	332	333	334	335	336	337	338	339	340	341	342	343	344	345	346	347	348	349	350	351	352	353	354	355	356	357	358	359	360	361	362	363	364	365	366	367	368	369	370	371	372	373	374	375	376	377	378	379	380	381	382	383	384	385	386	387	388	389	390	391	392	393	394	395	396	397	398	399	400	401	402	403	404	405	406	407	408	409	410	411	412	413	414	415	416	417	418	419	420	421	422	423	424	425	426	427	428	429	430	431	432	433	434	435	436	437	438	439	440	441	442	443	444	445	446	447	448	449	450	451	452	453	454	455	456	457	458	459	460	461	462	463	464	465	466
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Prog Rev: A



07 03 13

(30)

2-Deburr if necessary

Jan 07/03/21

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3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

[illegible]

*(continued)*

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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

40 QC8 SECOND CHECK

[illegible]

\_\_\_\_\_

**Comment:** SECOND CHECK

11/07/03/19

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50 BRAKE NC NC BRAKE

\_\_\_\_\_

Continued

Form Joggle as per Dwg D3429 on brake using Jig DT8158

SB 07/03/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/04/05

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.03.29	7	2059B HARD WAT USED INSTEAD OF AIR560 QTY (30)	CP 07.03.30 PV C/S 042	PARTS ACCEPTABLE PER ATTACHED DS EMAIL	KE 07/03/30	M 07/03/30	CP 07.03.29 PV C/S 042	M 07/07/30

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 8:38:25 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 31037

Part Number: D34291

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

M 07/03/22 (30)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R560Hardcoat

M102755

Weld hardcoat as per Dwg D3429

FC 070327 (30)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

M 07/03/30 (30)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M 07/03/30 (30)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FD

07/04/03 (30)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/04/04 (30)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/04/04 (30)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

07/04/05

Job Completion



U 07/04/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

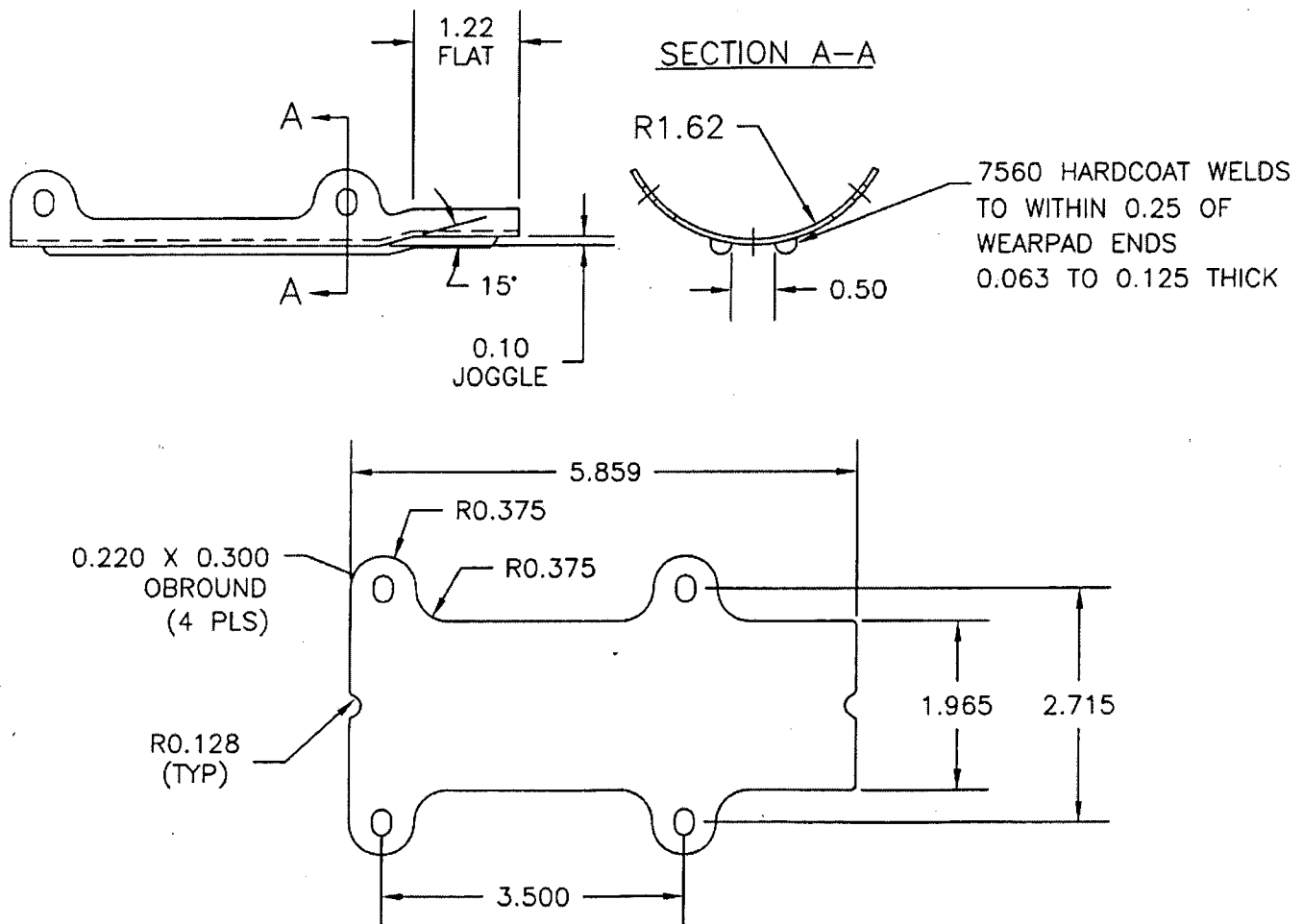
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3429	REV. A SHEET 1 OF 1
DATE 05.04.18		TITLE WEARPAD	SCALE 1:2
A	05.04.18	NEW ISSUE	

**RELEASED**  
05.09.06**D3429-1 WEARPAD**

- 1) BREAK ALL SHARP CORNERS 0.063 MAX
- 2) MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
- 3) FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) WELD PER DART QSI 004

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31037

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## Chris Provencal

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**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** March 29, 2007 6:11 PM  
**To:** 'Chris Provencal'  
**Cc:** 'S Shahbazian'; 'Bill Beckett (E-mail)'; 'Dale Trepanier'; 'Susanne Sheldon'  
**Subject:** RE: NCR D3429-1

I don't know how we did this to 20 wearpads, but I would tend to agree with you.  
Acceptable deviation in my opinion.

If we haven't already done so, I would suggest we create an NCR to investigate further to prevent this from happening in the future. In my opinion, this would be unacceptable in reverse (carbon steel welds on stainless steel wearplates).

David

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**From:** Chris Provencal [mailto:cprovencal@dartaero.com]  
**Sent:** Thursday, March 29, 2007 1:58 PM  
**To:** David Shepherd (David Shepherd)  
**Cc:** 'S Shahbazian'  
**Subject:** NCR D3429-1

Qty (20) D3429-1 Wearpads, those are the pads at the back end of the skidtube. They used the wrong weld rod when putting on the hard facing; used the new stainless steel rod on regular steel wearpads. Is this acceptable?

There will be increased chance of galvanic corrosion of the steel, but it seems the steel wearpads seem to rust regardless.

-Chris

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No virus found in this incoming message.  
Checked by AVG Free Edition.  
Version: 7.1.413 / Virus Database: 268.18.22/739 - Release Date: 3/29/2007

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No virus found in this outgoing message.  
Checked by AVG Free Edition.  
Version: 7.1.413 / Virus Database: 268.18.22/739 - Release Date: 3/29/2007